

SP11/17
21/11/06
NO SP11/17

Dart Aerospace Ltd.

Date: Thursday, 10/08/2006 10:01:04 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ASPIRATOR
Job Number	: 28120 -1		
Estimate Number	: 11483		
P.O. Number	: <i>N/A</i>	Part Number	: D2091
This Issue	: 10/08/2006	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2091REV. A
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 25264	Drawing Revision	: A
	Type : LARGE FAB ASSY	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 08/09/2006
Checked & Approved By	: <i>[Signature]</i>	Qty:	10 Um: Each
Comment	: Est: C 99.01.18 Re-format DM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :								
1.0	D2000043	Jet								
<div>Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)</div> <div>Jet</div> <div>Pick:</div> <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>1</td><td>D2000-043</td><td>Jet</td><td>→ <u>322741</u> → 9 <u>328128</u> → 1</td></tr></table> <div><i>CPL 06.11.20</i> (10)</div>			Qty	Part Number	Description	Batch	1	D2000-043	Jet	→ <u>322741</u> → 9 <u>328128</u> → 1
Qty	Part Number	Description	Batch							
1	D2000-043	Jet	→ <u>322741</u> → 9 <u>328128</u> → 1							
2.0	D2094	Aspirators								
<div>Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)</div> <div>Aspirator</div> <div>Pick:</div> <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>1</td><td>D2094 <u>D2094</u></td><td>Aspirator Body</td><td><u>328133</u></td></tr></table> <div><i>CPL 06.11.20</i> (10)</div>			Qty	Part Number	Description	Batch	1	D2094 <u>D2094</u>	Aspirator Body	<u>328133</u>
Qty	Part Number	Description	Batch							
1	D2094 <u>D2094</u>	Aspirator Body	<u>328133</u>							
3.0	D2095	Aspirator								
<div>Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)</div> <div>Aspirator</div> <div>Pick:</div> <table><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>1</td><td>D2095 <u>D2095</u></td><td>Aspirator Core</td><td><u>315535</u></td></tr></table> <div><i>CPL 06.11.20</i> (10)</div>			Qty	Part Number	Description	Batch	1	D2095 <u>D2095</u>	Aspirator Core	<u>315535</u>
Qty	Part Number	Description	Batch							
1	D2095 <u>D2095</u>	Aspirator Core	<u>315535</u>							
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1								
<div>Comment: LARGE FAB RESOURCE 1</div> <div>Weld D2000-043 Jet to D2094 Aspirator Body as per Dwg D2091 using Jig DT8294</div> <div><i>CPL 06.11.20</i> (10)</div>										

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/08/2006 10:01:04 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR

Job Number: 28120

Part Number: D2091

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

06/14/20

(10)

6.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting PURCHASING

Issue P/O: 2520

C 20611121

Black Anodize weldment from step 3 and Dwg D2095

(10)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ANODIZE

206-12-13

(9) ASSYS

8.0

A1449

Grommet



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Grommet

Pick:

Qty Part Number Description Batch
4 A1449 Grommet

M1487

X36

ml

9.0

A1622

Grommet



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Grommet

Pick:

Qty Part Number Description Batch
4 A1622 Grommet

M1487

X36

ml

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Install grommets as per Dwg D2091

ml 06/12/12

X9

PTD

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

206-12-14

(8)

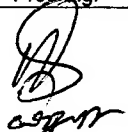

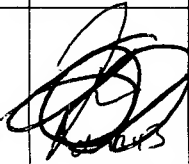
6.1
Transit Damage

06/12/08

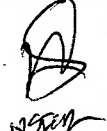





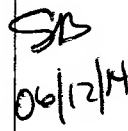
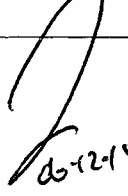
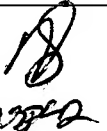

(19)

PTD

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06/12/13	6.1	10 split for Qty of Add Receiving: Inspect for transit damage. Permanent Change						
06/12/13	10.0	Find 100 gms off on 1622 grammit for in process						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/12/13
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/12/13	6.1	1x D2094 weldment is missing from Andolize, or before Andolize. Remaining is 9x D2094 weldments: 10x D2095 Aspirator core.		See NCR 119, and I.D. stock 1x D2095 Aspirator core.	 06/12/13	 06/12/13	 06/12/13	 06/12/13
06/12/13	10.0	1 part scrap. → 1 grammit had to be replaced when it was removed the hole was enlarged. Scrap: destroyed. 1 part 2 grammits are no good.		change the 2 grammits, Scrap: destroy the 1 part.	 06/12/14	 06/12/14	 06/12/14	 06/12/13

NOTE: Date & initial all entries

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User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR

Job Number: 28120

Part Number: D2091

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST214*

4 BQ/12/14

(8)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Doc 12/15 *(8)*

Job Completion



4 06-12-15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

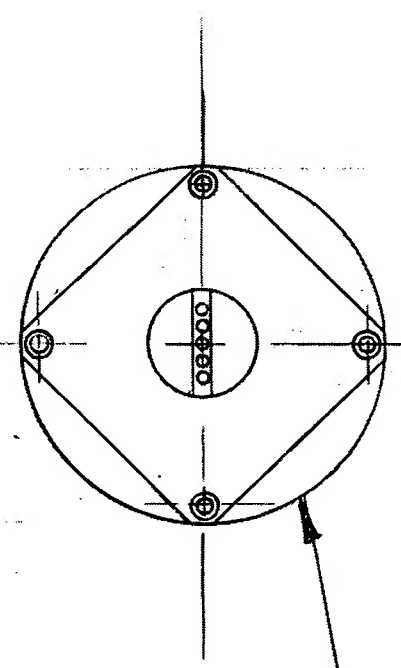
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

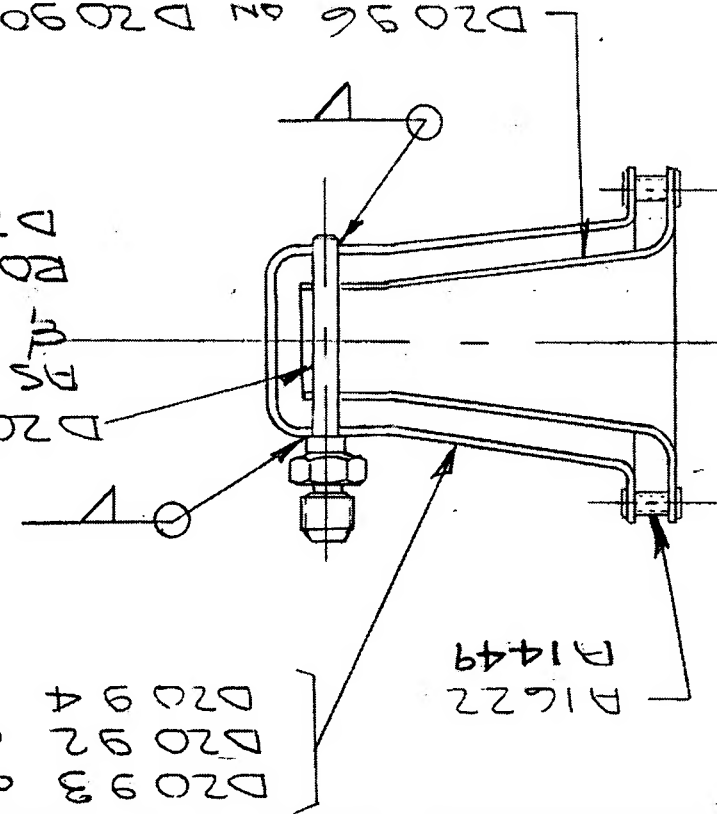
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D2092 SHOWN



A1622
A1449



D2093 ON D2090 (45°)
D2092 ON D2089 (45°)
D2094 ON D2091 (50°)

D2000-43
AS SHOWN ON D2092
D2093
ROTATED 45° ON
D2094

RELEASED
89-10-15

D2096 ON D2090
D2095 ON D2089 & D2091

FINISH:
BLACK ANODIZE AFTER WELDING
PRIOR TO RIVETING



15/06/68020

REVISION		REVISION	DATE	BY	DESCRIPTION	OF	CHANGE
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TNM**ANODISATION et PEINTURE TNM INC.**

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / AS9100 certified

approuvé NADCAP approved

51576

30-Nov-2006

**CLIENT / CUSTOMER:****DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE**CERTIFICAT DE CONFORMITE****PURCHASE ORDER/****NO. DE COMMANDE: 00002520**

ITEM	COMMANDE	DATE	DATE	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
	ORDERED		SHIPPED		
1	19	19		D2091 B28120	AS PER DWG D2091 REV. A BLACK ANODIZE PER MIL-A-8625F1 TYPE 1 CLASS 2

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.
Travel cards have been filed and are available for viewing upon request.

Signature/Signed: _____

☐ Directeur de la Qualité / Q.A. Manager ☐ ☐ ☐